

Work Order ID 166434

Friday, September 22, 2017 7:28:47 AM

166434*Ship**SEPT 26*

Page 1

Item ID: D058-678-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: OH-58 Bearpaws

Start Date: 9/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/26/2017 Req'd Qty: 1.00

1

Customer:

Reference:

DAS**21****9-89**

Approvals:

Process Plan:

Date: **SEP 22 2017**

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2435

Rev E1

sl
SEP 22 2017

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D058-678-011 CHG 001

DAS
28
9-89**SEP 25 2017**

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

DAS
6
9-89**SEP 22 2017****DAS**
27
9-89

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

DAS
28
9-89

Work Order ID 166434***166434***

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Friday, September 22, 2017 7:28:47 AM

Item ID: D058-678-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: OH-58 Bearpaws

Start Date: 9/22/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/26/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00					DAS 28 9-89		
Packaging	Identify and pack for shipping as per PPPD058-678-011 Location: F9014								SEP 22 2017
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00					DAS 21 9-89		SEP 26 2017
Quality Control									

DAS
21
9-89

SEP 26 2017

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D058-678-011

Required Qty: 1.00

60

Picklist Print

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Page 2

Work Order ID: 166434

166434

Parent Item: D058-678-011

D058-678-011

Parent Item Name: OH-58 Bearpaws

Start Date: 9/22/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

AN4-15A Purchased No

170 Each 102.0000 8 8

AN4-15A

Bolt

**

SEP 22 2017

DAS 27 9-89

D/ 2 9-8

Location

Loc Qty

Loc Code

GA

10

120449

10

ST343

92

m138336

92

8

AN4-17A Purchased No

170 Each 43.0000 8 8

AN4-17A

Bolt

**

SEP 22 2017

DAS 27 9-89

Location

Loc Qty

Loc Code

ST343

43

M138230

43

8

AN960JD416 NAS1149D0463J Purchased No

170 Each 0.0000 8 8

AN960JD416

Washer

**

138230

DAS 27 9-89

D2529 Manufactured No

170 Each 375.0000 8 8

D2529

Washer

**

SEP 22 2017

SEP 22 2017

Location

Loc Qty

Loc Code

ST008

375

160670

3

164975

372

3

Picklist Print

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Page 3

Work Order ID: 166434

166434

Parent Item: D058-678-011

D058-678-011

Parent Item Name: OH-58 Bearpaws

Start Date: 9/22/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

170

Each

1,734.000

8

8

MS21042L4

Nut

**

DAS 27
6 9-89 SEP 22 2017

Location

Loc Qty

Loc Code

FP001

10

m133363

10

OVER007

500

m138230

500

ST303

1224

m138170

500

m138326

724

8

QS200-M44S

Purchased

No

170

Each

24.0000

2

2

QS200-M44S

CLAMP

**

DAS 27
6 9-89 SEP 22 2017

Location

Loc Qty

Loc Code

ST545

24

m133363

4

m137951

20

2

D2435

Manufactured

No

170

Each

4.0000

2

2

D2435

Bearpaw

**

DAS 27
6 9-89 SEP 22 2017

Location

Loc Qty

Loc Code

ST446A

4

164728

4

2

Friday, September 22, 2017 7:28:53 AM

Shop Packet Print

Page 3

QA COPY ISSUED

RELEASED
98.06.17 KE

98.06.17 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
98.05.19		D2435	SHEET 1 OF 2
DATE	TITLE	SCALE	
98.05.19	BEARPAW	1:5	
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

750
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166434

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

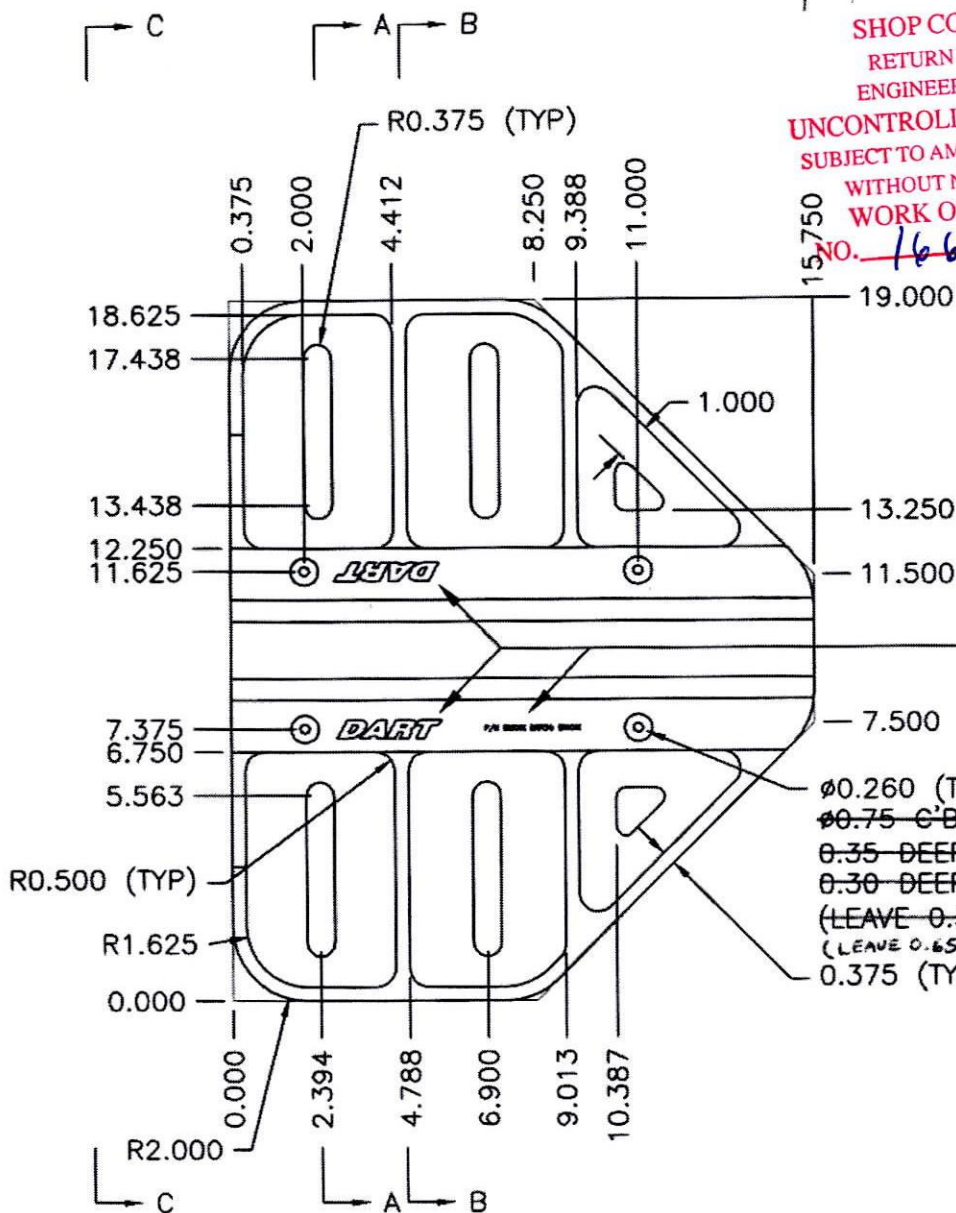
MIN.)

E

E

EFFECTIVE DEOS

9143

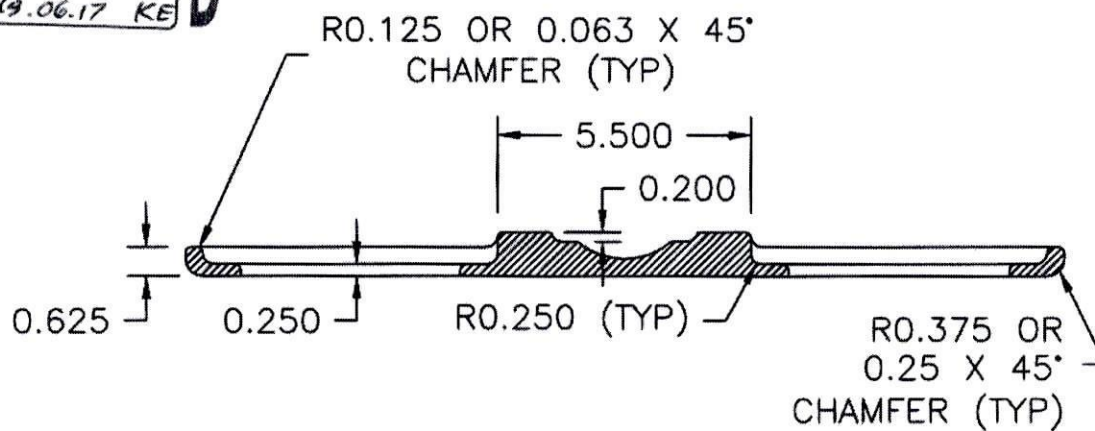


MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

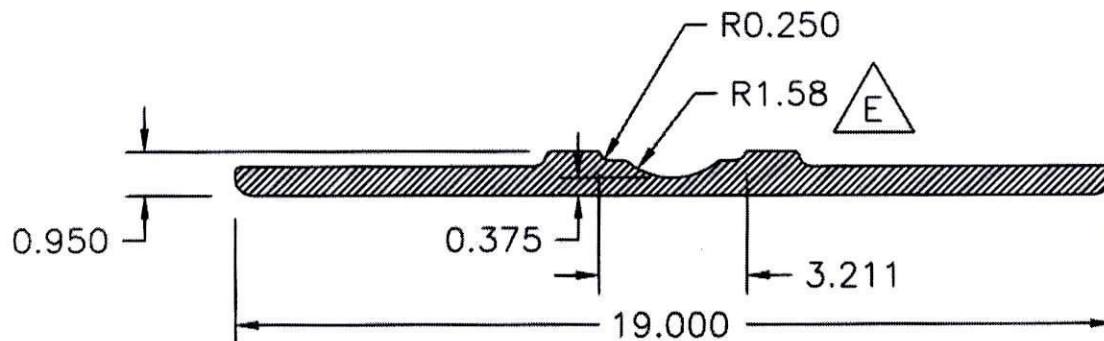


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DB</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

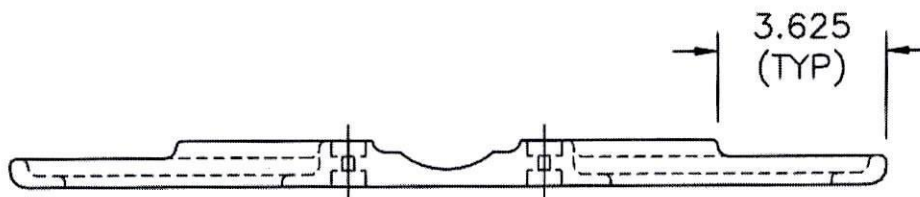
RELEASED
98.06.17 KE



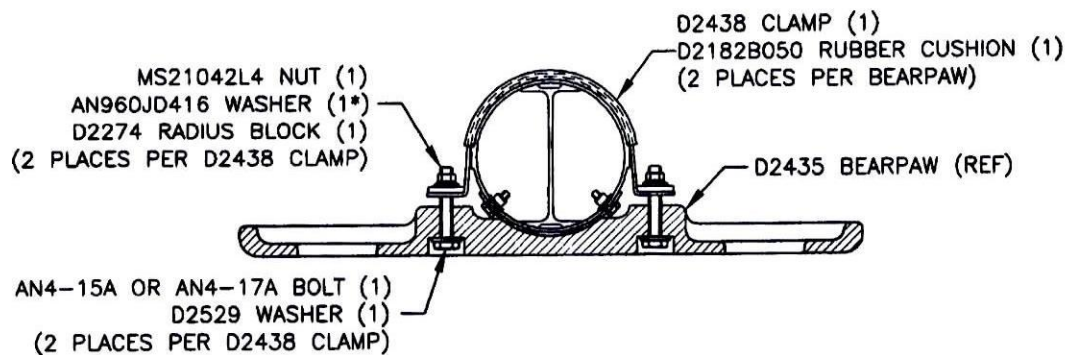
SECTION A-A



SECTION B-B



SECTION C-C



* See note 3

Figure 2 - Bearpaw Installation

4. The QS200M44S clamps must be installed behind the fwd D2438 clamps to ensure that the bearpaw doesn't slip.

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D058-678-011	8.5 lb	0.0 in	0.0 in-lb	142.4 in	1210.4 in-lb
Bearpaw Installation	3.86 kg	0.0 m	0.0 m-kg	3.62 m	13.97 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D058-678-011	BEARPAW INSTALLATION
4	D2182B050	RUBBER CUSHION
8	D2274	RADIUS BLOCK
2	D2435	BEARPAW
4	D2438	CLAMP
8	D2529	WASHER
8	AN4-15A	BOLT
8	AN4-17A	BOLT
8	AN960JD416	WASHERS
8	MS21042L4	NUT (OR MS21042-4)
2	QS200M44S	CLAMP

Work Order ID 166434

Friday, September 22, 2017 7:28:47 AM

166434

Ship

Set 1 ✓

Page 1

Item ID: D058-678-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: OH-58 Bearpaws

Stop ***NS2***

Start Date: 9/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/26/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: **SEP 22 2017**

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2435	Rev E1	SEP 22 2017							
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork Photocopy bluefile and create labels per PPP D058-678-011 CHG 001									
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS
5
9-89**SEP 25 2017****SEP 22 2017**



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<http://www.dartaero.com>

INSTRUCTIONS FOR CONTINUED AIRWORTHINESS

ICA-D058-678

Bearpaw Installation

BELL OH-58 A+/A/C MODELS

Prepared By: *C. Provencal*
C. Provencal
Mechanical Designer

Checked By: *D. Shepherd*
D. Shepherd, P. Eng.
Design Engineer

Released By: *D. Shepherd*
D. Shepherd, P. Eng.
Design Engineer

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Revision: 0